

Work Order ID 85803

85803

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June 15, 2012 12:57:46 PM

Item ID: D3216-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fitting

Start Date: 6/15/12

Start Qty: 16.00

16

Cust Item ID:

Required Date: 6/20/12

Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 12/06/15 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3216

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3216 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

304 - 125"

16

0

Jun 12-6-15

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

16

0

Jun 12-6-15

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

80/100/100

(26)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3216-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fitting
Start Date: 6/15/12 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 6/20/12 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab							B12-6-18	
Small Fab	Memo	0.00							(16)
Small Fab	Tumble until parts have a polished finish.								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							(H16)
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location:								
Packaging	Memo	0.00							
Packaging									

~~Check~~
ST033

CL 12/06/19 16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3216-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fitting
Start Date: 6/15/12 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 6/20/12 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/6/2012

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 15, 2012 12:57:45 PM

Page 1

Work Order ID: 85803

Parent Item: D3216-1

Parent Item Name: Fitting

Start Date: 6/15/12

Required Date: 6/20/12

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP: A03.10.28New IssueKJ/RF
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

96.0760

0.0288

0.4850526

304/316 0.125 Sheet

Jm 12-6-15

Location

Loc Qty

Loc Code

MAT020

96.076

121380

24.9

121780

71.176

121780

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	85803
Description: Fitting		Part Number:	D3216-1
Inspection Dwg: D3216 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.600	+/-0.010	2.600"	✓		✓	mm
2.010	+/-0.010	2.009"	✓		✓	"
0.295	+/-0.010	0.297"	✓		✓	"
1.548	+/-0.010	1.554"	✓		✓	"
1.004	+/-0.010	1.008"	✓		✓	"
0.295	+/-0.010	0.302"	✓		✓	"
0.250	+/-0.010	0.242"	✓		✓	"
0.125	+/-0.010	0.120"	✓		✓	"

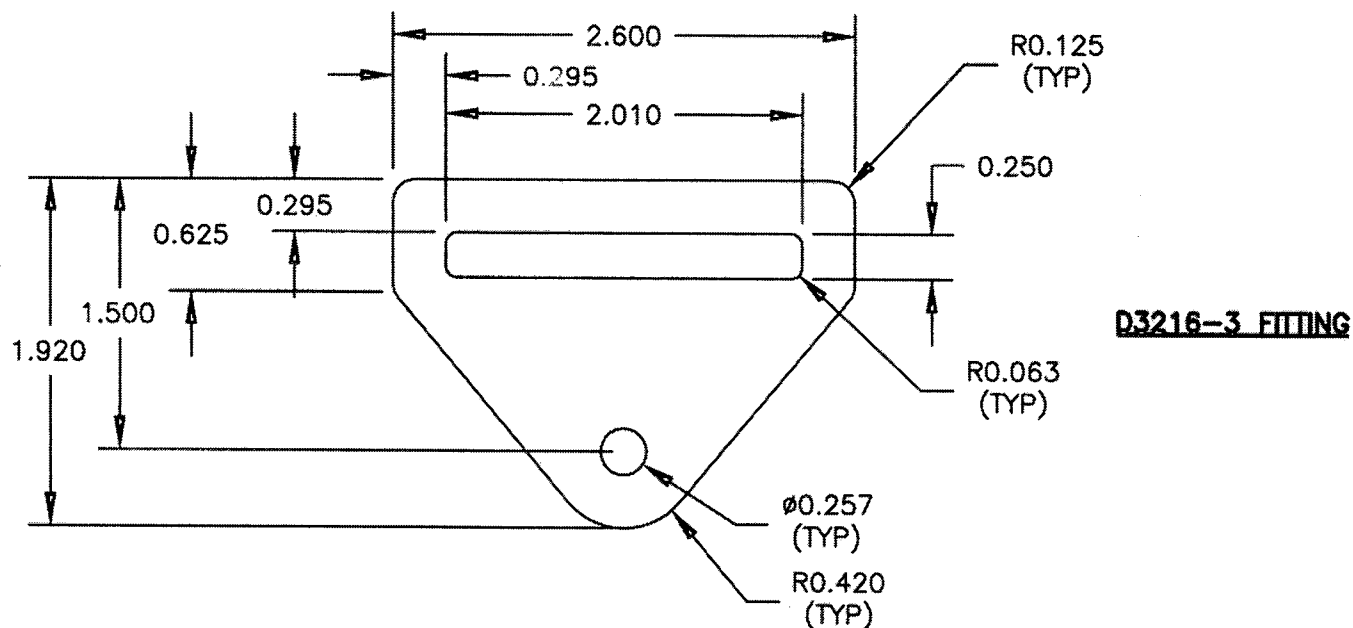
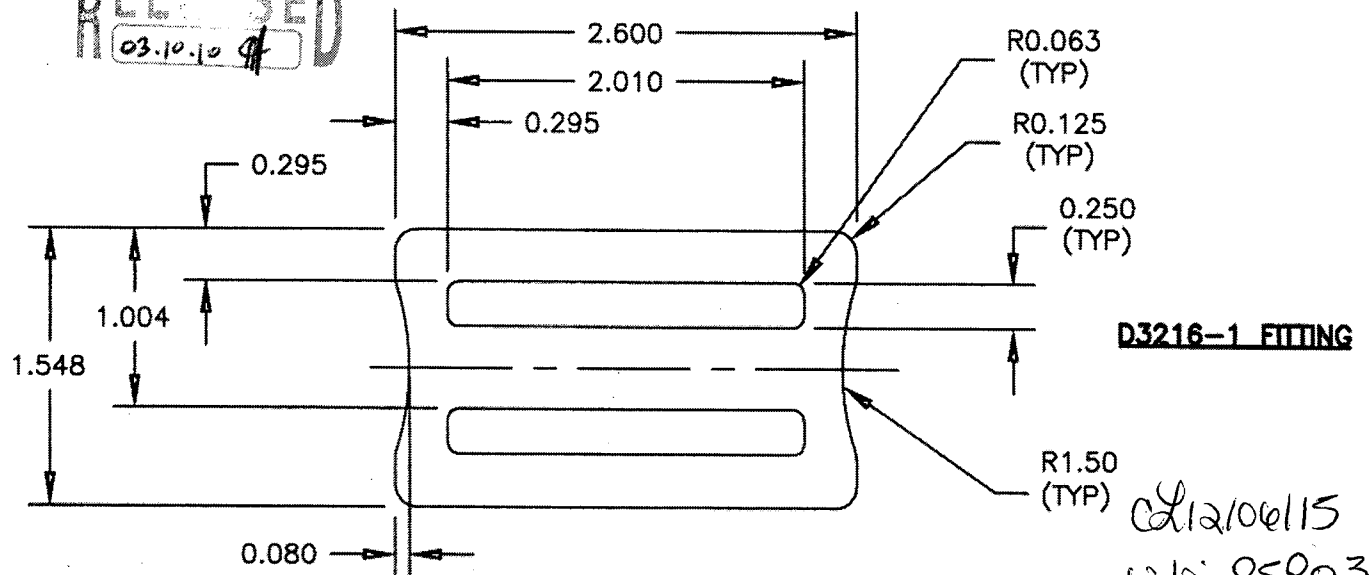
Measured by:	Jm	Audited by:	S	Prototype Approval:	N/A
Date:	12-6-15	Date:	12/08/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3216	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	

RELEASED
03.10.10



D3216-1/-3 FITTING

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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